



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D130-1048-041
Job Sheet 196762



Part No: D130-1048-041

Job Qty: 1 pcs

Part Name: H130/EC130 - Replacement Skidtube - Standard - LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/20/19

Job Tracking No:

Due Date: 7/12/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D130-1048-041 REV.B/ IIN-D130-1048 REV.C IPP REV:A 18.08.15 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
150	Skidtubes - 1	1 pcs	7/12/19		0.00	2.00	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
160	QC 5	1 pcs	7/12/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
162	Handfinish - 1-1 Chemical-B4B	1 pcs	7/12/19		0.00	0.33	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		
							Handfinish - 1 - 5 - B4B		
							Handfinish - 1 - 6 - B4B		
							Handfinish - 1 - 7 - B4B		



Container No: S203285



Part: D130-1048-041

Job No: 196762

Serial No/Batch: S203285

Revision: B/C

Inspector:

Exp Date:

Instructions: TC STC SH19-4 Issue 1

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

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					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
164 QC 7	1 pcs	7/12/19	0.00 0.00	QC 7 - 10		
				QC 7 - 13		
				QC 7 - 14		
				QC 7 - 15		
				QC 7 - 17		
				QC 7 - 18		
				QC 7 - 19		
				QC 7 - 2		
				QC 7 - 28		
				QC 7 - 3		
				QC 7 - 30		
				QC 7 - 34		
				QC 7 - 36		
				QC 7 - 37		
				QC 7 - 41		• A2 19-8-10
				QC 7 - 47		
				QC 7 - 48		
				QC 7 - 51		
				QC 7 - 58		
				QC 7 - 59		
				QC 7 - 60		
				QC 7 - 9		
				QC 7 - 68		
				QC 7 - 50		
				QC 7 - 67		
				QC 7 - 40		
				QC 7 - 24		
				QC 7 - 43		
166 Outsource - 2 - NDT per QSI038	1 pcs	7/12/19		SKY002-VC	5	2019-08-13
170 Packaging 2-1 - Receive - B4B	1 pcs	7/12/19	0.00 0.00	Packaging 2 - 1 - B4B		
				Packaging 2 - 2 - B4B		
				Packaging 2 - 3 - B4B		
				Packaging 2 - 5 - B4B		

				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
180	QC 6	1 pcs	7/12/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
182	Spray Paint - 2 - B4B	1 pcs	7/12/19	0.00 0.50	Spray Paint - 1 - B4B
					Spray Paint - 2 - B4B
					Spray Paint - 3 - B4B
					Spray Paint - 4 - B4B
184	QC 14	1 pcs	7/12/19	0.00 0.00	QC 14 - 15
					QC 14 - 2
					QC 14 - 34
					QC 14 - 41
					QC 14 - 51
					QC 14 - 58
					QC 14 - 59
					QC 14 - 9
					QC 14 - 68
					QC 14 - 40
					QC 14 - 19
					QC 14 - 43
					QC 14 - 24
190	Handfinish - 4-1-Assembly-B4B	1 pcs	7/12/19	0.00 1.00	Handfinish - 4 - 1 - B4B
					Handfinish - 4 - 10 - B4B
					Handfinish - 4 - 11 - B4B
					Handfinish - 4 - 12 - B4B

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RD 19-8-14

AUG 14 2019 DAS
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A8 19-8-15

					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	
					Handfinish - 4 - 4 - B4B	
					Handfinish - 4 - 5 - B4B	
					Handfinish - 4 - 6 - B4B	
					Handfinish - 4 - 7 - B4B	
					Handfinish - 4 - 8 - B4B	
					Handfinish - 4 - 9 - B4B	
200 QC 5	1 pcs	7/12/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
230 Spray Paint - 3 - B4B	1 pcs	7/12/19	0.00 1.00	Spray Paint - 1 - B4B	• AS 19-8-16	
				Spray Paint - 2 - B4B		
				Spray Paint - 3 - B4B		
				Spray Paint - 4 - B4B		
240 QC 14	1 pcs	7/12/19	0.00 0.00	QC 14 - 15	U 19-8-21	
				QC 14 - 2		
				QC 14 - 34		
				QC 14 - 41		
				QC 14 - 51		
				QC 14 - 58		
				QC 14 - 59		
				QC 14 - 9		
				QC 14 - 68		
				QC 14 - 40		
				QC 14 - 19		
				QC 14 - 43		
				QC 14 - 24		
250 Handfinish - 4-2-Assembly-B4B	1 pcs	7/12/19	0.00 0.17	Handfinish - 4 - 1 - B4B	U 19-8-21	
				Handfinish - 4 - 10 - B4B		
				Handfinish - 4 - 11 - B4B		
				Handfinish - 4 - 12 - B4B		
				Handfinish - 4 - 13 - B4B		
				Handfinish - 4 - 14 - B4B		
				Handfinish - 4 - 15 - B4B		

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260 QC 5	1 pcs	7/12/19	0.00 0.00	Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	DAG
270 Packaging 3-1 - Stock - B4B	1 pcs	7/12/19	0.00 0.00	QC 5 - 49	19
				QC 5 - 51	9-03
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	FD-004 Hl 19-8-21
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	

				Packaging 3 - 35 - B4B		DAS 21
				Packaging 3 - 36 - B4B		9-89
280 DC - 1 - B4B	1	7/12/19	0.00 0.00	DC - 1 - B4B	AUG 21 2019	DAS 77
	pcs			DC - 2 - B4B		9-89
290 QC 21 - FG	1	7/12/19	0.00 0.00	QC 21 - FG - 21		DAS 77
	pcs			QC 21 - FG - 70		9-89
				QC 21 - SA - 53	AUG 21 2019	DAS 77

Part Op 150 - 1-Remove bending marks longitudinally. ***Use Linemate*** 2-Identify as per note 6. 3-Insert skidtube in DT10416
 Descriptions: A, position tube so that bend sect. rest against DT10448B. Bottom out FWD end against DT10448C. Use clamp to hold tube. ***BEND SECT. AND SADDLE MUST BE WITHIN 1 DEGREE OF TUBE C/L.*** Drill all pilot holes. Cleco as you drill. 4-Open holes to finish size at section B-B, C-C and D-D 5- Cleco D5571-1 saddle in previously drilled pilot holes. Transfer drill remaining saddle holes into D5611-1 skidtube. Open holes to finish size. ***SEE NOTE 11, SHEET 1, THESE ARE THE ONLY TWO HOLES THAT CAN NOT BE OPEN TO SIZE*** *****SADDLE MUST BE IDENTIFY TO SKIDTUBE***** 6-Cleco DT10431 on two previously drilled FWD wear plate holes and drill remaining four FWD wear plate holes (SECT. E-E) Cleco DT10439 on two previously drilled AFT wear plate holes and drill remaining four AFT wear plate holes (SECT. C-C) . 7-Open holes section C-C, D-D and E-E to finished size. 8-Chamfer AFT end of tube as per DWG sheet 2 note 8. 9-Chamfer FWD end of tube as per DWG sheet 2 note 9. 10-Open blade fitting holes and deburr as per note 5. Test fit blade fitting.
 160 - (QC5- Inspect part completeness to step on W/O)
 164 - (QC7-Inspect Chemical Conversion Coat)
 166 - (Outsource process - NDT per QSI038 4.1), ISSUE P/O: _____ Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order NDT C OF C IS REQUIRED
 170 - (Receive & Inspect for Damage & Mat'l Certs), Ensure copy of NDT results attached to work order.
 180 - (QC6- All purchased or subcontracted products)
 182 - PRIME AREA SHOWN (TO 1.0 BELOW CENTERLINE), PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER) BATCH: 5199127
 184 - (QC14- Inspect Spray Paint)
 190 - (Assemble as per dwg), 1-Wet install and seal faying surface saddle with Maxibolt rivets as per DWG sheet 1 note 8 and 9 ***EXCEPT THE TWO TOP HOLES.*** Pro Seal 890 B 5176610 EXP 19/10 ***VERY IMPORTANT TO LET A 12HR CURE TIME*** 2- As per note 11 on sheet 1. Open the top remaining holes to size, use #8 drill (0.199") 3-Touch up Alodine the two holes with ALODINE 600 4- Install the two remaining Maxibolt rivets as per dwg 5-Shave rivets as required. 6-Remove chips from inside of tube and clean tube. Prepare for final inspection. 7- FILLET SEAL ALL AROUND SADDLE WITH OR PROSEAL 890 OR EQUIVALENT MIL-S-8802 CLASS B SEALANT
 200 - (QC5- Inspect part completeness to step on W/O)
 230 - PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER) AFTER ASSEMBLY PRIME BATCH: 5199127 ***NOTE***do not paint inside saddle bore. Primer only. PAINT OUTSIDE PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT) AFTER ASSEMBLY PAINT BATCH: 5204428
 240 - (QC14- Inspect Spray Paint)
 250 - (Assemble as per dwg), Install inserts as per DWG sheet 1 note 10.
 260 - (QC5- Inspect part completeness to step on W/O)
 270 - (Identify as per dwg & Stock Location: _____), Identify and pack for shipping as per PPP D130-1048-041
 Location: _____ PPP Rev: _____
 280 - Photocopy blue file & type labels per PPP D130-1048-041 CHG001
 290 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5571-1	Saddle	1 pcs (1 ea)	150-Skidtubes - 1	5200878
D5611-1	EC130 Skidtube	1 pcs (1 ea)	150-Skidtubes - 1	5167500
CR7621S-06-05	Rivet <u>+2 scrap</u>	22 Ea (22 ea)	190-Handfinish - 4-1-Assembly-B4B	5108055
ALS4-1032-225	Rivnut	8 Ea (8 ea)	250-Handfinish - 4-2-Assembly-B4B	5174308

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
150-Skidtubes - 1	D5571-1	1	0	0
	D5611-1	1	14	0
190-Handfinish - 4-1-Assembly-B4B	CR7621S-06-05	22	209	0
250-Handfinish - 4-2-Assembly-B4B	ALS4-1032-225	8	1,069	0

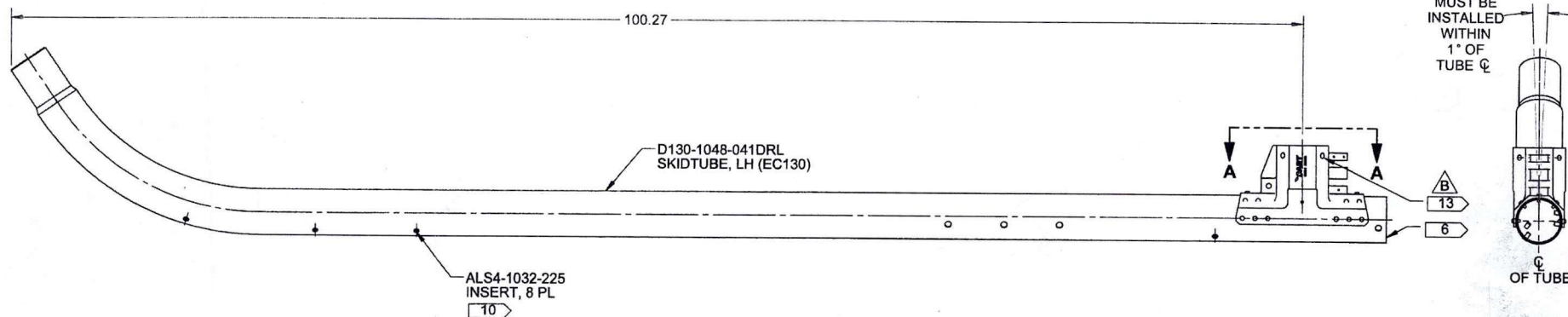
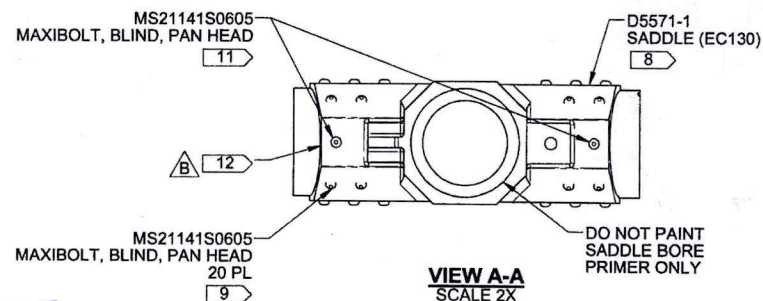
Part Specifications

Specifications could not be found.

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QTY -041	P/N	DESCRIPTION
X	D130-1048-041	SKIDTUBE ASSY, LH (EC130)
1	D130-1048-041DRL	SKIDTUBE, LH (EC130)
1	D5571-1	SADDLE (EC130)
22	MS21141S0605	MAXIBOLT, BLIND, PAN HEAD (CR7621S06-05)
8	ALS4-1032-225	INSERT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **196762 HWS**
190620



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER) AFTER ASSEMBLY
PAINT OUTSIDE PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT) AFTER ASSEMBLY
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D130-1048-041" AND S/N PER DART QSI 044 6.4
ON INSIDE OF TUBE, MAX 0.5" FROM AFT END OF TUBE
- 7) WEIGHT: 20.29 lbs
- 8) SEAL FAYING SURFACE WITH PROSEAL 890 OR EQUIVALENT MIL-S-8802 CLASS A SEALANT
- 9) POSITION SADDLE AND TRANSFER DRILL $\phi 0.193$ HOLE PATTERN FROM SADDLE ONTO SKIDTUBE.
OPEN HOLES THRU SADDLE AND SKIDTUBE TO $\phi 0.199 - \phi 0.202$. TOUCH-UP HOLES WITH CHEMICAL FILM (ALODINE 1200)
PER MIL-DTL-5541. WET INSTALL MAXIBOLTS WITH PROSEAL 890 OR EQUIVALENT MIL-S-8802 CLASS A SEALANT
- 10) INSTALL ALS4 INSERTS IN EXISTING $\phi 0.297$ HOLES AFTER FINISH
- 11) TRANSFER DRILL $\phi 0.193$ HOLES FROM SADDLE TO SKIDTUBE. OPEN HOLES THRU SADDLE AND SKIDTUBE
TO $\phi 0.199 - \phi 0.202$. ENSURE CLEAN HOLES FOR GOOD ELECTRICAL BONDING. TOUCH-UP HOLES WITH
ELECTRICALLY CONDUCTIVE CHEMICAL FILM (ALODINE 600) PER MIL-DTL-5541. INSTALL MAXIBOLTS DRY (NO SEALANT)
- 12) FILLET SEAL ALL AROUND SADDLE WITH SIKAFLEX-241/-291 OR PROSEAL 890 OR EQUIVALENT MIL-S-8802 CLASS B SEALANT
- 13) MASK SADDLE HOLES BEFORE PRIME AND PAINT

RELEASED

2019 JUN 19 NO
ECN 19-625

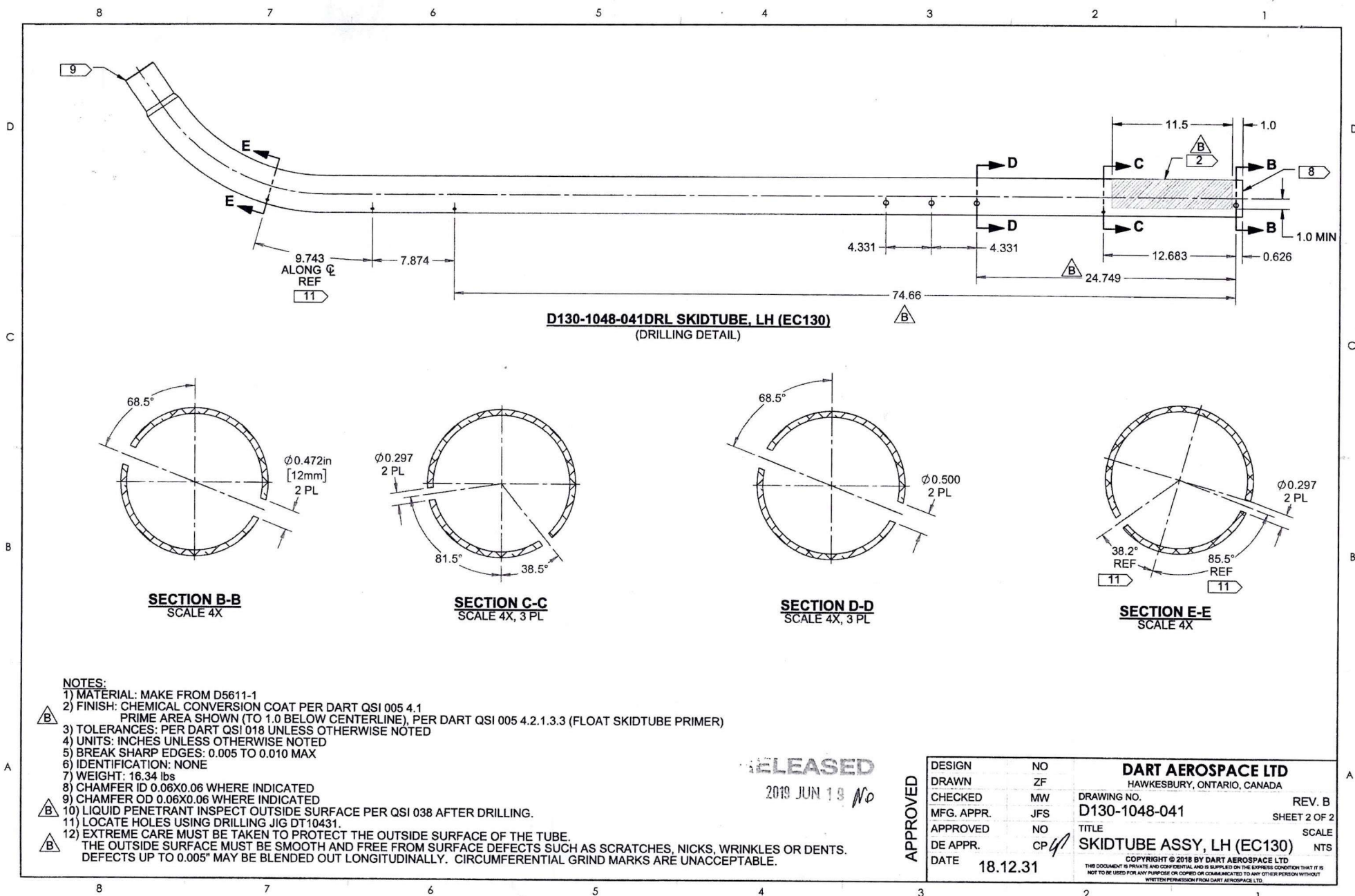
B	REDRAWN BOTH SHEETS, D130-1048-041: ADDED PRIME TO FINISH NOTE. ADDED CLASS A SEALANT FOR FAY SEAL AND WET INSTALL MAXIBOLTS. INSTALL ALS 4 INSERTS AFTER FINISH. ADDED NOTE 12. D130-1048-041DRL: PRIME IN AREA SHOWN WAS PRIME INSIDE AND OUTSIDE. LPI AFTER DRILLING WAS PRIOR TO DRILLING. ADDED NOTE 12. REDIMENSION FROM BLADE HOLE INSTEAD OF TUBE END	ZF	18.12.31
A	NEW ISSUE	ZF	18.05.07
REV.	DESCRIPTION	BY	DATE
DESIGN	NO		
DRAWN	ZF		
CHECKED	MW		
MFG. APPR.	JFS		
APPROVED	NO		
DE APPR.	CP		
DATE	18.12.31		

APPROVED

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D130-1048-041** REV. B
TITLE **SKIDTUBE ASSY, LH (EC130)** SCALE NTS

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044239



Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

Attention: Jenne, Heather

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044239
PO Date: 8/12/19
Due Date: 8/13/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com
Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	197937	D119-796-251	Aft Crosstube Installation With Step (No Hardware) : TC STC SH14-45-Issue 1, FAA STC SR03504NY 15/01/28, EASA STC 10052022 Revision 1 15/02/13, DGCA INDIA LoA 07-09/2011-AED (Part) 15/07/16, BRAZIL STC 2015S07-16 15/07/30, CAAP PHILIPPINES LoA 16/05/11, CHINA VSTC0757 16/07/22, RUSSIA STC CT316-A119 16/08/11, DGAC INDONESIA STC SR025 18/02/19 ISSUE P/O: *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** C OF C IS REQUIRED	Firmed	-	8/13/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	197938			Firmed	-	8/13/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
Sub Total:							2	0	2		\$239.00



Dart Aerospace Ltd.
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Hawkesbury, ON
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PURCHASE ORDER

POHB044239



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	197723	D206-667-203	Aft Crosstube - High 206L / L1 / L3 / L4 : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 (Outsource process - NDT per QSI038 4.1), *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Issue P/O: _____ LPI as per ASTM 1417	Firmed	-	8/13/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	197724			Firmed	-	8/13/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
Sub Total:							2	0	2		\$239.00
3	197725	D206-667-201	Aft Crosstube - High 206 A/B : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 (Outsource process - NDT per QSI038 4.1), *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***	Firmed	-	8/13/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	197726			Firmed	-	8/13/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
Sub Total:							2	0	2		\$239.00
4	196763	D130-1048-041	H130/EC130 - Replacement Skidtube - Standard - LH : TC STC SH19-4 Issue 1, FAA STC SR04320NY dated 19/03/26 (Outsource process - NDT per QSI038 4.1), ISSUE P/O: _____ Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order NDT C OF C IS REQUIRED	Firmed	-	8/13/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	196762			Firmed	-	8/13/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
Sub Total:							2	0	2		\$239.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044239



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	196766	D130-1048-042	H130/EC130 - Replacement Skidtube - Standard - RH : TC STC SH19-4 Issue 1, FAA STC SR04320NY dated 19/03/26 (Outsource process - NDT per QSI038 4.1), ISSUE P/O: Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order NDT C OF C IS REQUIRED	Firmed	-	8/13/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	196767			Firmed	-	8/13/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
Sub Total:							2	0	2		\$239.00

Grand Total: \$1,195.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/13/19 1:55 PM Dart.Guerin.Kimberley

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO41392	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: POHB044239 ✓
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:**CARRY OUT NDT ON:**

✓ 2 REPLACEMENT SKIDTUBE-STANDARD-LH , P/N: D130-1048-041 , J/S: 196762 , 196763

✓ 2 REPLACEMENT SKIDTUBE-STANDARD-RH , P/N: D130-1048-042 , J/S: 196766 , 196767

✓ 2 AFT CROSSTUBES , P/N D119-796-251 , J/S: 197937 , 197938

✓ 2 AFT CROSSTUBES , P/N: D206-667-203 , J/S: 197723 , 197724

✓ 2 AFT CROSSTUBES , P/N: D206-667-201 , J/S: 197725 , 197726

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-16 NO CRACK FOUND PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142						AUG 13 2019	 
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp 	Date:
Name: RAFIK MELIKIAN		AUG 13 2019